

## CLAIMS

What is claimed is:

1. A method of balancing a brake drum comprising the steps of:  
providing a brake drum having a generally cylindrical body with an open end and a hub end,  
the brake drum body including an integral raised squealer band near the open end,  
the squealer band having a generally uniform thickness around its entire circumference,  
with an outer edge of the squealer band forming its outer circumference,  
removing a portion of the squealer band from the outer edge inwardly to form a section of the squealer band with a continually varying thickness.
2. The method of claim 1  
wherein the formed section of the squealer band with the continually varying thickness has an outer edge of a generally flat plane.
3. The method of claim 1  
wherein the formed section of the squealer band with the continually varying thickness has an outer edge of a generally flat, concave surface.
4. The method of claim 1  
wherein the formed section of the squealer band with the continually varying thickness has an outer edge comprised of a first planar, generally flat section extending at an angle from a first area of decreasing thickness of the squealer band and

of a second planar, generally flat section extending from the first area at an angle to form a second area of increasing thickness of the squealer band.

5. The method of claim 1

wherein the formed section of the squealer band generally forms a chord across the squealer band.

6. A brake drum comprising

a generally cylindrical body with an open end and a hub end,

the brake drum body including an integral raised squealer band near the open end,

the squealer band having a generally uniform thickness, except for a formed portion of the squealer band having a reduced, continually varying thickness.

7. The brake drum of claim 6

wherein the formed portion of the squealer band has an outer edge of a generally flat plane.

8. The brake drum of claim 6

wherein the formed portion of the squealer band has an outer edge of a generally flat, concave surface.

9. The brake drum of claim 6

wherein the formed portion of the squealer band has an outer edge comprised of a first

planar, generally flat section extending at an angle to form a first area of decreasing thickness of the squealer band

and a second planar, generally flat section extending from the first area at an angle to form a second area of increasing thickness of the squealer band.

10. The brake drum of claim 6

wherein the formed portion of the squealer band generally forms a chord across the squealer band.

11. A method of balancing a brake drum comprising the steps of:

providing a brake drum having a generally cylindrical body with an open end and a hub end,

the brake drum body including an integral, raised, generally cylindrical squealer band near the open end,

the squealer band having a generally uniform radial thickness measured from an internal surface of the open end of the brake drum to an outer circumferential edge of the squealer band,

removing a portion of the squealer band from a first point on its outer circumferential edge inwardly and back to a second point on its circumferential edge to form a section of the squealer band with a continually varying thickness.

12. The method of claim 11

wherein the section of the squealer band with the continually varying thickness has a generally flat, planar outer edge.

13. The method of claim 11

wherein the section of the squealer band with the continually varying thickness has a generally concave outer surface.

14. The method of claim 11

wherein the section of the squealer band with the continually varying thickness has a first generally planar section extending at an angle from the outer circumferential edge to form a first area of the section of the squealer band with the continually varying thickness,

and a second generally planar section extending at an angle from the first area back to the outer circumferential edge to form a second area of the section of the squealer band with continually varying thickness.

15. The method of claim 11

wherein the section of the squealer band with the continually varying thickness has a generally convex outer surface.

16. The method of claim 11

wherein the section of the squealer band with the continually varying thickness has a radius of curvature greater than the outer circumferential edge of the squealer band.